

Work Order ID 60077

June 24, 2010 9:05:46 AM

CHANGE DWELL



Page 1

Item ID: D3246-041

Revision ID:

Item Name: Mounting Bracket

Start Date: 6/24/10 Start Qty: 4.00

Required Date: 7/02/10 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3246

Rev A1

100



FLOW WATER JET

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg Dsi9279
Deburr if necessary

Dwg Rev: A1

Prog Rev: A1

12-

B10-6-30

Deburr -> m. L. w/07/06

(4X)

(4)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B10-6-30

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

Solo 206

(5)

(3)

Pto ->

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3246-041 PAR #: _____ Fault Category: prod-eng error NCR: Yes No DQA: _____ Date: 10/7/09
 Resolution: _____ Disposition: _____ QA: N/C Closed: Yes Date: 10/07/09

NCR: <u>60077</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/6/09	100	Found at inspection that aty's parts have wear in/out in some of the holes. P.C. Program error	<u>[Signature]</u>	→ Scrap + Destroy aty + 3 - no repair B <u>111381</u>	<u>[Signature]</u> 10-6-09	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u> 10/6/09
			<u>[Signature]</u>	→ Fix Program				<u>[Signature]</u> 10/6/09
			<u>[Signature]</u>	→ ac to keep aty + 1 Per construction template				

NOTE: Date & initial all entries

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Item ID: D3246-041

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Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Deburr Form as per Dwg D3246 IC sink as per Dwg D3246

0.00 SB 10/07/14

4 EP 10/07/26 (5)

(5)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

5.10/07/27

(X)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

=> M 10/07/25

X5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 60077

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Page 3

Item ID: D3246-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Bracket

Start Date: 6/24/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

5 BR 10-7-08.

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Nut Plates as per Dwg D3246

5/10/07/28 (5)

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/10/07/28

(5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 60077

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Page 4

Item ID: D3246-041

Accept



Setup Start



Revision ID:

Item Name: Mounting Bracket

Stop



Start Date: 6/24/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



Packaging

Identify as per dwg & Stock Location: *Qty*

0.00

Memo

0.00

Packaging

6/24/10 *g*

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/07/29 *H*

W 1007-28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DOA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 60077

Parent Item: D3246-041

Parent Item Name: Mounting Bracket

Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-06-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			170	sf	118.6947	0.3097	1.304			

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

118.6947

111381

22.3

113189

0.3947

114968

96

MS20426AD3-3

Purchased

No

170

Each

4,864.000

8

Rivet

Location

Loc Qty

Loc Code

ST316

4864

19099

4774

7681

90

MS21059L3

Purchased

No

110

Each

96.0000

4

Nut Plate

Location

Loc Qty

Loc Code

ST301

85

114718

85

ST302

11

113749

10

114456

1

1310-6-29

④

11381

32
6/30/07/28

40

16

6/30/07/28

20

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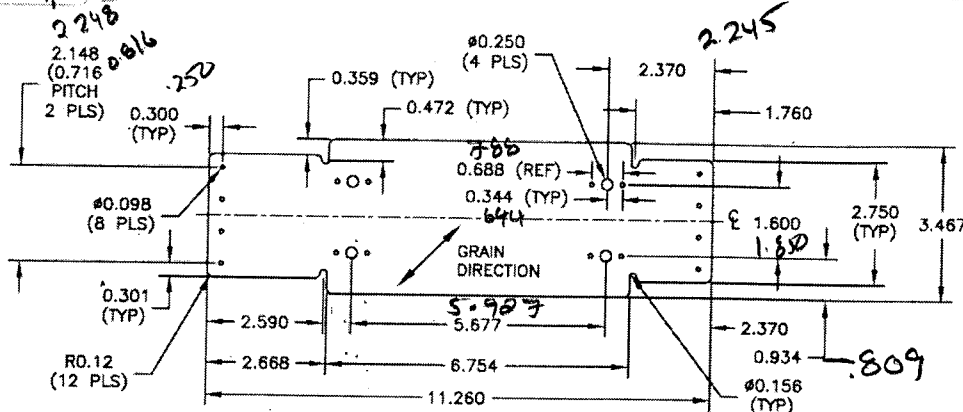
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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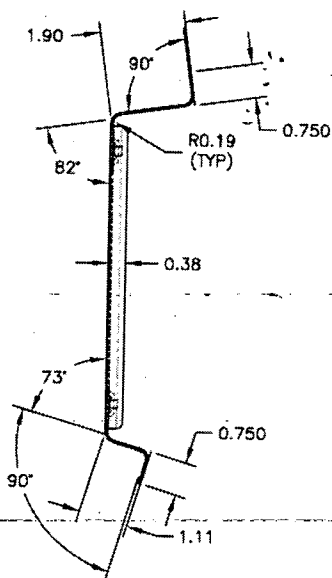
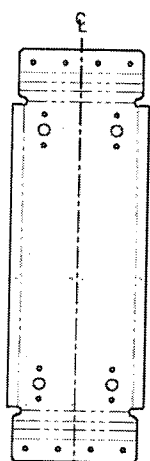


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3246	REV. A SHEET 1 OF 1
DATE 04.04.21	TITLE MOUNTING BRACKET	SCALE 1:4	
A	04.04.21	NEW ISSUE	
AI	CHANCE RIVET	ADDED F SINK	

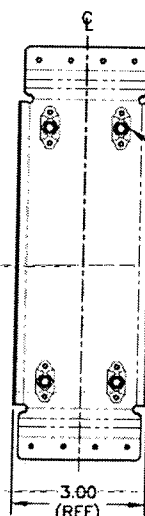
RELEASED
04.05.07



D3246-1 FLAT PATTERN



D3246-1 BEND DETAIL



MS21059-L3
NUT PLATE (1)
MS20470AD3-4 RIVET (2)
(4 PLACES)
INSTALL AFTER
ALODINE
C/SINK OF 0.156 X 0.156
MS20470AD3 3 RIVET (2)

D3246-041 ASSEMBLY

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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